

Work Order ID 53340

Page 1

November 2, 2009 7:55:45 AM

Item ID: D2893-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: 2.75 Support

S.

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *PJ*

Date: 09-11-02 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2893	Rev B

100



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

mmt 09/11/09

10 ✓

HAAS CNC vertical machine #1

Machine as per Folio FA081 □ Tumble & Deburr

110



QC2- Inspect parts off machine FAI/FAIB

0.00

mmt 09/11/09

10 ✓

QC

Quality Control

120



QC8- Inspect parts - second check

0.00

88 09/11/10

10 ✓

QC

Quality Control

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

1112148

Powder Coating

Memo

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

BK 09-11-11



0.00

Memo

150



SprayPaint

SprayPaint

0.00

M 09 11 12 15

0.00

Memo

Spray Painting

Prime inside surface as per Dwg D2893 and QSI 005 4.3

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Setup Start



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Stop



Item Name: 2.75 Support

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC14- Inspect Spray Paint

0.00

BT 09 11 24 CO

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *Tables ASSY*

0.00

ML 09 11 24 10

Packaging

Memo

0.00

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/25 AD

MF 09-11-24

DART AEROSPACE LTD	Work Order:	53340
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.994	2.994	2.993
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.130	.140	.138	.137	.137
AD	0.040	0.060		.050	.050	.049	.050	.051
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.137	.138	.140	.140	.139
AG	0.140	0.160		.152	.162	.150	.152	.150
AH	1.360	1.400		1.372	1.376	1.376	1.367	1.369
AI	0.040	0.060		.054	.055	.051	.053	.054
AJ	1.190	1.230		1.216	1.229	1.217	1.213	1.215
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.536	2.537	2.532	2.534	2.534
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.265	.264	.264	.264	.264
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: MVE Date: 09/11/08

Audited by: SP Date: 09/11/10

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	SP

DART AEROSPACE LTD	Work Order:	53340
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	10
HAAS Section								
AA	2.985	3.005		2.994	2.994	2.994	2.994	2.995
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.147	.149	.146	.148	.146
AD	0.040	0.060		.050	.050	.049	.051	.051
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.138	.140	.140	.140	.140
AG	0.140	0.160		.150	.152	.150	.151	.150
AH	1.360	1.400		1.370	1.370	1.370	1.370	1.370
AI	0.040	0.060		.052	.054	.054	.053	.053
AJ	1.190	1.230		1.214	1.217	1.212	1.207	1.212
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		R.063	R.063	R.063	R.063	R.063
AM	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AN	2.518	2.538		2.529	2.538	2.532	2.537	2.538
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.264	.264	.265	.265	.264
AQ	0.053	0.073		R.063	R.063	R.063	R.063	R.063
AR								
AS								
AT								
Accept/Reject								

Measured by: MNT Date: 07/11/09

Audited by: JF Date: 09/11/10

Prototype Approval: _____ Date: _____

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